

Work Order ID 50367

July 14, 2009 2:48:19 PM



Page 1

Item ID:	D3931-1	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Angle					
Start Date:	7/10/09	Start Qty: 8.00		Cust Item ID:		
Required Date:	7/15/09	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan: <u>MF</u>	Date: <u>09-07-15</u>	Tooling:		Date:		Run	Start	
	QC:	Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

13 97-22

13 97-22



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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July 14, 2009 2:48:19 PM



Page 2

Item ID: D3931-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 7/10/09

Start Qty: 8.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

2) S 09/07/23

11

1



QC

Memo

0.00

Quality Control

130

Brake NC
Memo

0.00

SB 09/07/23

11

1



Brake NC

Memo

0.00

Brake NC

1- bend as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00

2) S 09/07/23

11

1



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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July 14, 2009 2:48:19 PM



Page 3

Item ID: D3931-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 7/10/09

Start Qty: 8.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: 139

0.00



Packaging

Memo

0.00

Packaging

PO 8/1/24 (11)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/24

mf 09-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

July 14, 2009 2:48:19 PM

Work Order ID: 50367

Parent Item: D3931-1RevA

Parent Item Name: Angle

Comments:

Start Date: 7/10/09

Required Date: 7/15/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No				sf	111.7100	0.1600			



304/316 .040 Sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	111.71	
110076	32.79	
111571	78.92	

110076 B 9-7-22

(11)

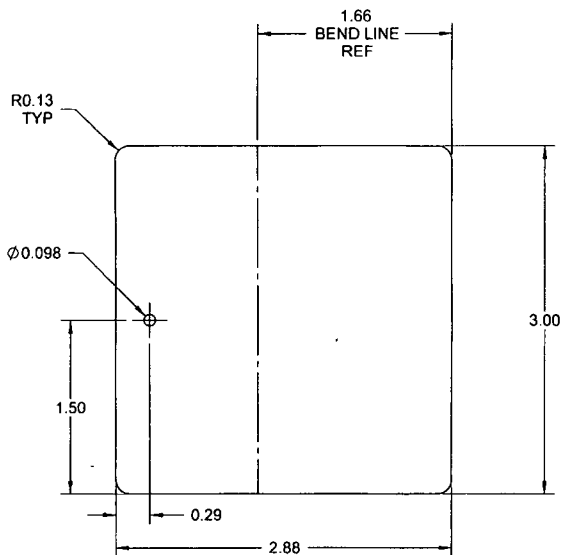
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

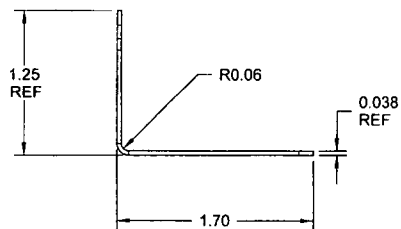
QA: N/C Closed: _____ Date: _____

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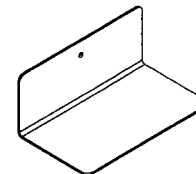
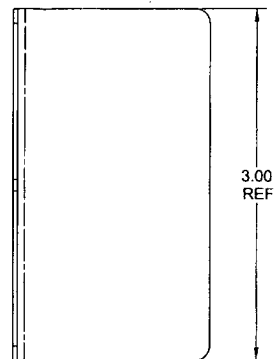
NOTE: Date & initial all entries



D3931-1F FLAT PATTERN



D3931-1 ANGLE
(MAKE FROM D3931-1F)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50367

MF 09-07-15

RELEASED
09/07/15

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
20 GAUGE (0.038 THICK)
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3931-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

A NEW ISSUE		PH	09.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3931	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	ANGLE	NTS
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